

Work Order ID 56651

Wednesday, March 03, 2010 1:00:59 PM



ASA P

Page 1

Item ID: D3741-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 3/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 10-3-3

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3741	Rev B

100

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-drill holes as per dwg D3741-2-Deburr

JL 10/03/07

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JL 10/03/07

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

JP 10/03/08

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Angle

Stop



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Required Date: 3/10/2010 Req'd Qty: 10.00



Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Grind radius as per dwg D3741 □ 2- Deburr if necessary JK 10/03/07

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/08

(+10)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

JK 10/03/08

(X10)

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Page 3

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Required Date: 3/10/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-3-8 SL (X)

170



Packaging

Packaging

Identify as per dwg & Stock Location: Steven WA

0.00

Memo

0.00

10-3-8 SL (X)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/11 (X)

MF
10-3-10

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Picklist Print

Wednesday, March 03, 2010 1:00:59 PM

Page 1

Work Order ID: 56651



Parent Item: D3741-1

Parent Item Name: Angle

Start Date: 3/3/2010

Required Date: 3/10/2010

Comments: IPP Rev:A 08-01-30 new issue DD verified by:
IPP Rev:B 08-03-19 chg to revB DD verified by:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6207		Manufactured	No			110	f	55.3333	0.6579			



Angle Extrusion



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

55.3333

46909

55.3333

1X1X-125 w

46909

66

SL 10/03/07

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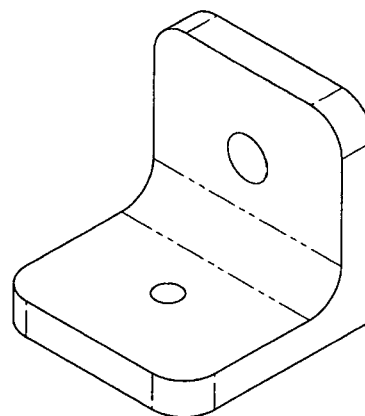
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





D3741-1 ANGLE 

#50651

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED. ISO VIEW UPDATED. SHEET 2 ZONE D5. Ø0.098 HOLE WAS Ø0.159, ZONE 6B Ø0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3741	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		ANGLE	NTS	
DATE	08.03.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

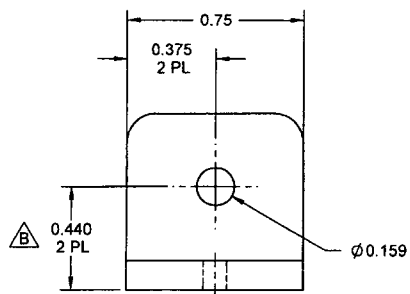
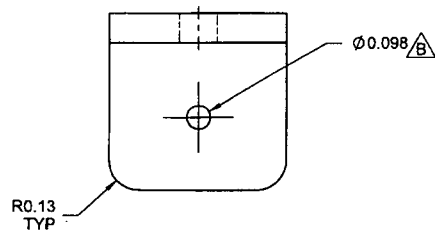
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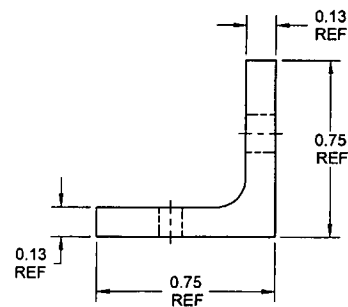
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D3741-1 ANGLE



50651

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>CE</i>	DRAWING NO. D3741	REV. B
MFG. APPR.	<i>JS</i>	SHEET 2 OF 2	
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	ANGLE	NTS
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